

Date: Monday, 12/01/2009 2:36:24 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DECK PLATE KIT
 Job Number : 44640
 Estimate Number : 11233
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D350616015
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D350-616 REV E
 Previous Run : 44006 Project Number : N/A
 Material :
 Due Date : 30/01/2009 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : JLD 09.01.13
 Comment :
 Est Rev:C Removed Manufacturing 05-12-05 JLM
 Est Rev:D Add D3494-1 05-12-05 JLM
 Est rev E added parts per NCR 08-041 08.04.30 EC
 verified by: DD
 Est Rev:F 08-12-10 rev.E as per dwg DD verified by:ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



for JLD 09/02/09



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D350-616-015 CHG002

8 09/02/09

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2344	Litter Deck Plate, 350
-----	-------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2344 Deck Plate (Aft) 38810

JS 09/02/05

4.0	D2348	Wearplate
-----	-------	-----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2348 Wear Plate (Key Way) B39578 x2 B39666 x10

JS 09/02/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 44640

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2353

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2353 Stiffener

39639

SS 09/02/05 (X3)

6.0

D2364

Deck Plate, Fwd 350 Litt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2364 Deck Plate (Fwd)

44775

SS 09/02/05 (X3)

7.0

D2365

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2365 Wear Plate (Pip Pin)

44424

SS 09/02/05 (X3)

8.0

D23691

Deck Plate Locator Brackets



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-1 Locator Plate

B44776 x2

44425 x1

SS 09/02/05 (X3)

9.0

D23693

Deck Plate Locator Brackets



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-3 Locator Plate

B44777

B44425 x1

SS 09/02/05 (X3)
SS 09/02/05 (X3)

10.0

AN960JD10

Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

10 AN960JD10 Washer

M109846

SS 09/02/05 (X3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 44640

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS20426AD45

Rivet



Comment: Qty.: 25.0000 Each(s)/Unit Total : 75.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-5 Rivet

M4067

SS 09/02/05 (3)

12.0

MS20426AD46

Rivet



Comment: Qty.: 25.0000 Each(s)/Unit Total : 75.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-6 Rivet

M105144

SS 09/02/05 (3)

13.0

MS20426AD57

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-7 Rivet

M1681

SS 09/02/05 (3)

14.0

MS20426AD58

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-8 Rivet

M4533

SS 09/02/05 (3)

15.0

MS20601AD4W2

Rivet



Comment: Qty.: 15.0000 Each(s)/Unit Total : 45.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 MS20601AD4W2 Blind Rivet

M110322

SS 09/02/05 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: .CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 44640

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS20601AD4W3

Rivet



Comment: Qty.: 30.0000 Each(s)/Unit Total : 90.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

30 MS20601AD4W3 Blind Rivet M167823.

17.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L3 Nut (or -3) M109798.

18.0

MS24693C48

Screw



Comment: Qty.: 22.0000 Each(s)/Unit Total : 66.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

22 MS24693-C48 Screw (or -48) M104215

19.0

MS24693C273

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS24693-C273Screw (or -273) M109962

20.0

D34941

Stub Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

STUB COVER

Batch: 41956

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 44640

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS35207264

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

batch:

M107959x5 M109031x7

SS 09/02/05

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 09/02/07

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-616-015

Location:

PPP Rev:

31
C

9/2/9

Se

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/11

Job Completion



MF 09-02-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
	1		D3179-041	LITTER TIE DOWN (NON-LOCKING)
		1	D3494-1	STUB COVER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (or CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (or CR9162-4-3)
		6	MS21042L3	NUT (or MS21042-3)
		6	MS24693-C273	SCREW (or MS24693-273)
		22	MS24693-C48	SCREW (or MS24693-48)
		4	MS35207-264	SCREW
		10	NAS1149D0363J	WASHER (or AN960JD10)

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WORK OR FOR

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BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 08.11.07
CERT. NO.: SH96-10
ISSUE NO.: 2

E	MAKE DSI 9310 STANDARD; D3179-041 REPLACES D2350	RF	08.11.07
D	ADD D3494-1 STUB COVER	MB	06.01.19
C	ADD DSI 9112/9117/9130/9236/9310	MB	06.01.10
B	ADD VIEW OF D2493 TO SHEET 9	BW	96.01.09
A	NEW ISSUE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D350-616	SHEET 1 OF 12
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DE APPR.	[Signature]	AS350/355 LITTER KIT INSTALLATION	NTS
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GENERAL NOTES:

1. COMPATIBILITY

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE RESPONSIBILITY OF THE INSTALLER. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

2. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE STANDARD SET BY THE AIRCRAFT MAINTENANCE MANUAL.

3. INSTALLATION INSTRUCTIONS

THIS DRAWING IS TO BE USED IN CONJUNCTION WITH INSTALLATION INSTRUCTIONS IIN-D350-616.

4. CONTINUING AIRWORTHINESS

THIS INSTALLATION SHOULD BE MAINTAINED IN ACCORDANCE WITH MAINTENANCE MANUAL SUPPLEMENT MMS-D350-616.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-616-011	31.3 lb	17.3 in	541.5 in-lb	63.8 in	1996.9 in-lb
Full Litter Kit	14.19 kg	0.44 m	6.24 m-kg	1.62 m	22.99 m-kg
D350-616-013	6.3 lb	15.4 in	97.0 in-lb	52.0 in	327.6 in-lb
Deck Plate & Tie Down	2.86 kg	0.39 m	1.12 m-kg	1.32 m	3.78 m-kg
D350-616-015	2.8 lb	15.6 in	43.7 in-lb	53.0 in	148.4 in-lb
Deck Plate Kit	1.27 kg	0.40 m	0.51 m-kg	1.35 m	1.71 m-kg
Person Approximate CG	lb	18 in	in-lb	72 in	in-lb
	kg	0.46 m	m-kg	1.88 m	m-kg

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BY: D. SHEPHERD (DE # 02)

DATE: 08.11.07
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WORK ORDER
NO. 44040

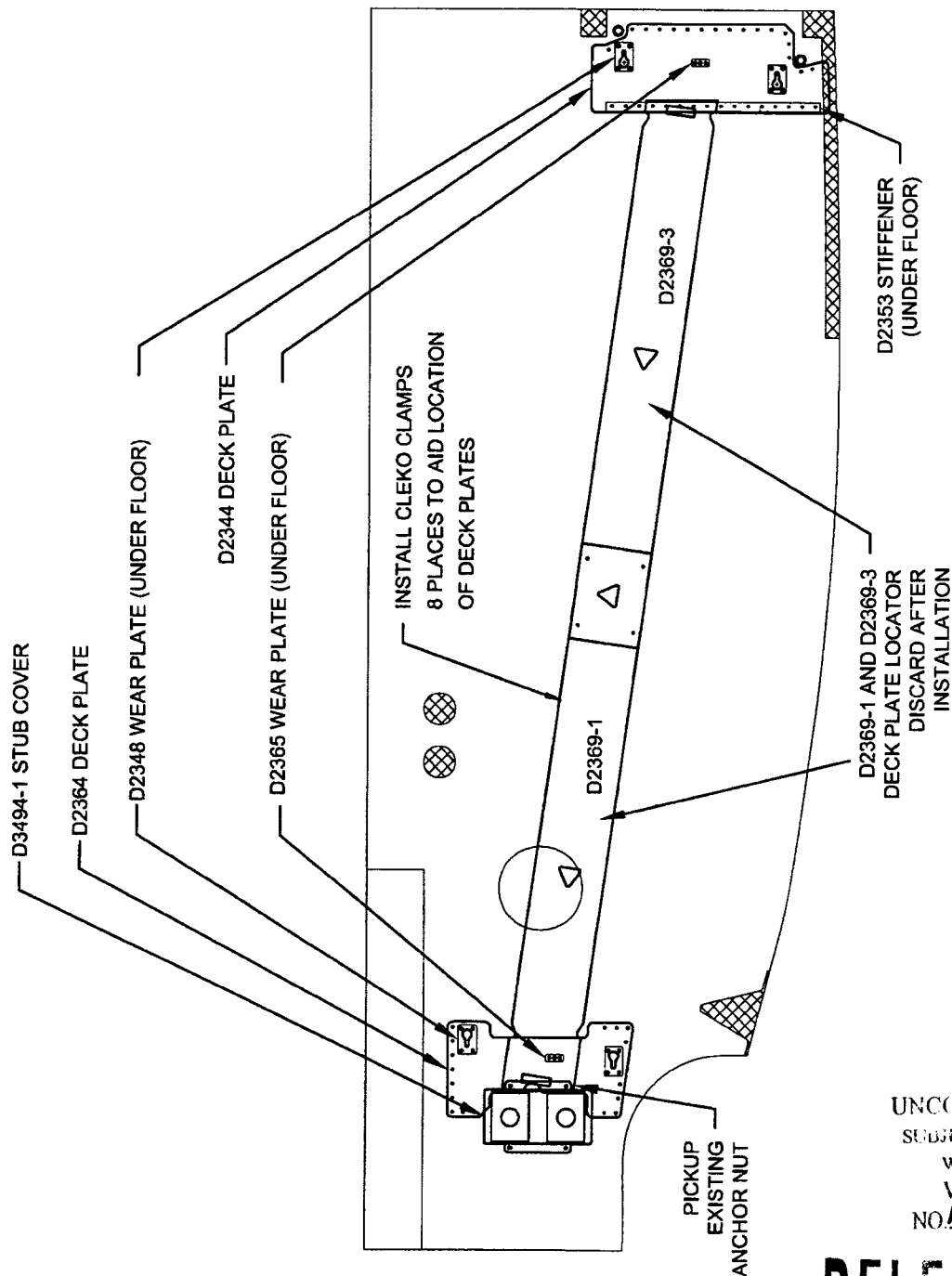


FIGURE 1

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO ALL COMMENTS
WITHIN 30 DAYS
NO. *HH/1040*

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08/11/21 MP

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DAO # 01-O-01

APPROVED
BY: *D. Shepherd*
D. SHEPHERD (DE # 02)
DATE: 08.11.07
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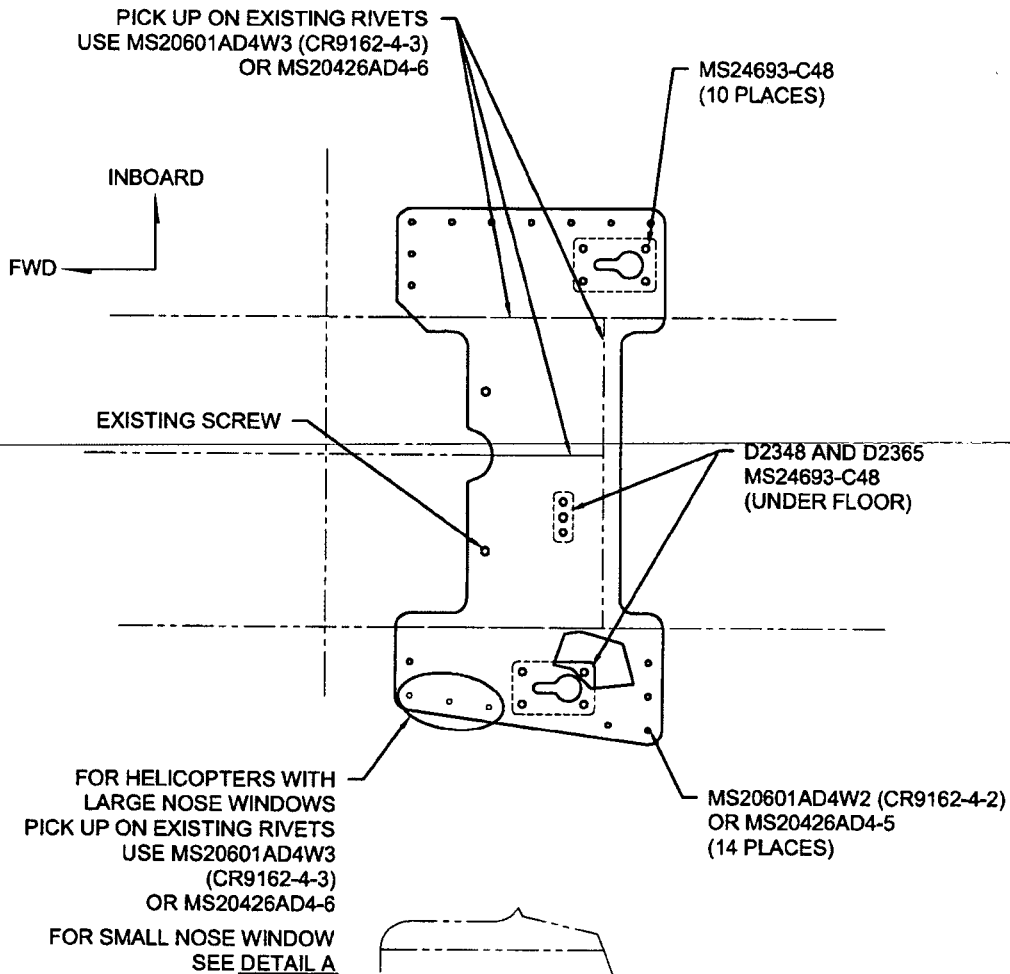
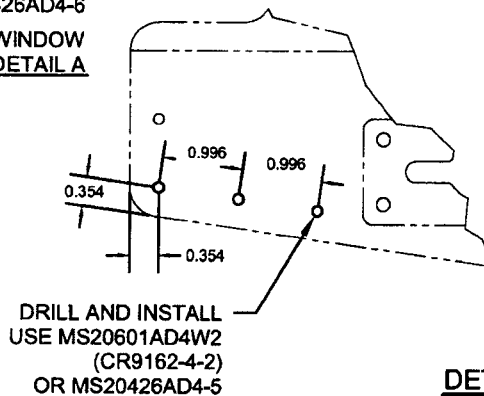


FIGURE 2



DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO ANY
WITHOUT
WORK GROUP
NO. 444040

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BRANCH
DAO # 01-O-01

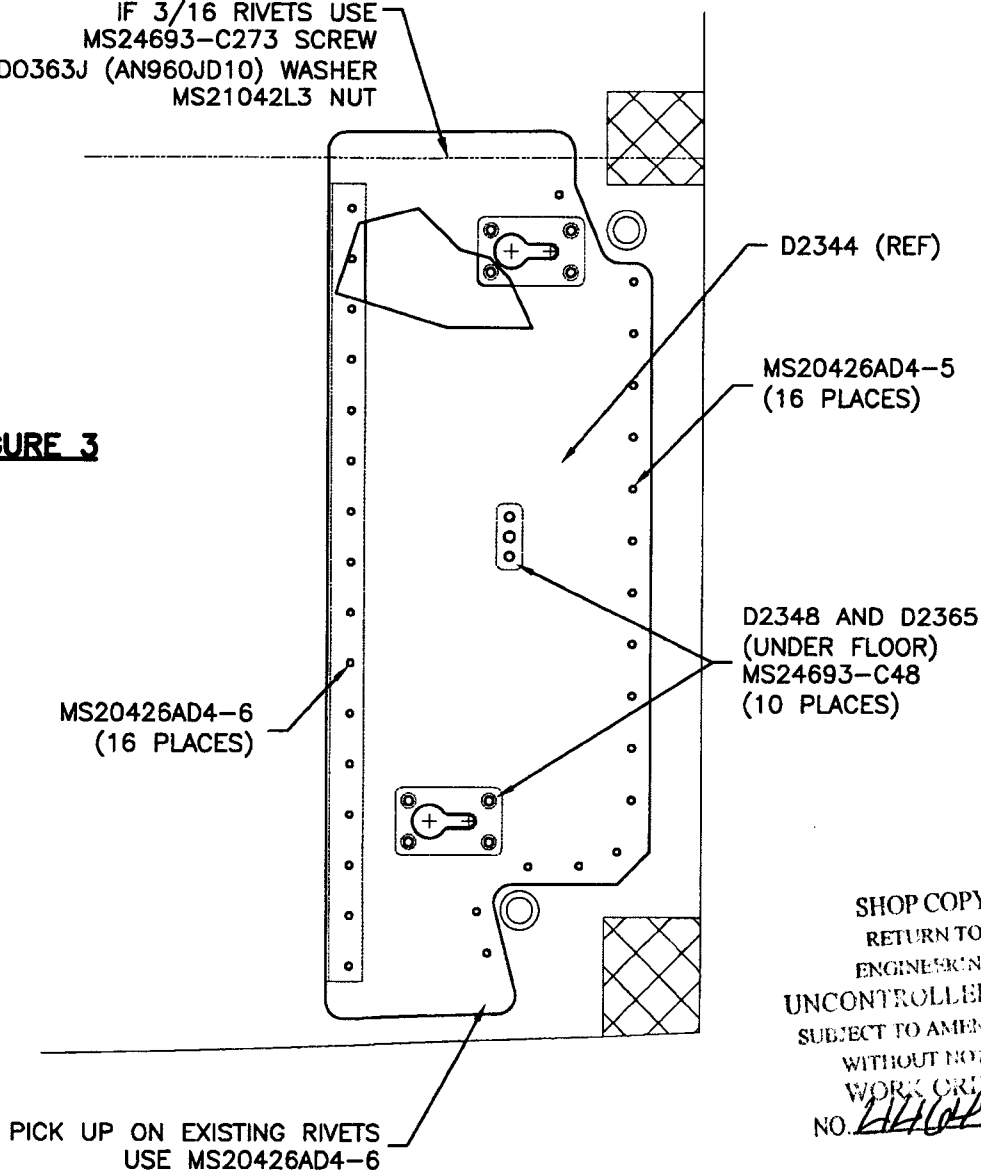
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BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

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CERT. NO.: SH96-10
ISSUE NO.: 2

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MFG. APPR.	N/A	D350-616	SHEET 4 OF 12
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PICK UP ON EXISTING RIVETS
 IF 5/16 RIVETS USE
 MS20426AD5-7/MS20426AD5-8
 IF 3/16 RIVETS USE
 MS24693-C273 SCREW
 NAS1149D0363J (AN960JD10) WASHER
 MS21042L3 NUT

FIGURE 3



SHOP COPY
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 44640

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 BRANCH
 DAO # 01-O-01

APPROVED

BY: [Signature]
 D. SHEPHERD (DE # 02)

DATE: 08.11.07
 CERT. NO.: SH96-10
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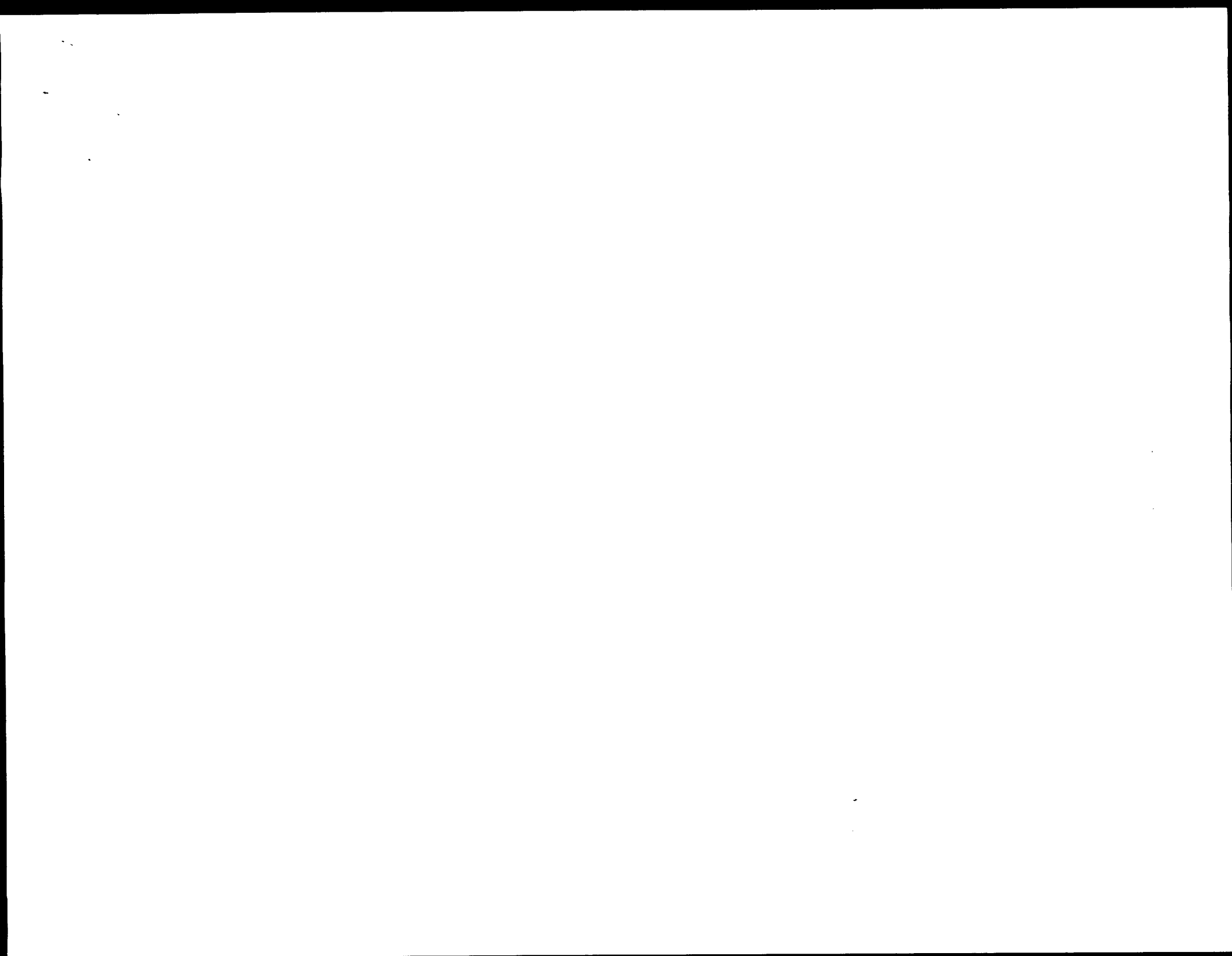


FIGURE 4: LITTER TIE DOWN INSTALLATION

D3494-1 STUB COVER
PICK UP ON EXISTING INSERTS:
USE EXISTING SCREWS OR
MS35207-264 SCREWS (4)
AND NAS1149D0363J (AN960JD10)
WASHERS (4)

D3179-041
LITTER TIE DOWN
(NON-LOCKING)

D2360
LITTER TIE DOWN
(LOCKING)

ACCEPTABLE TO TRIM
D3179-041 AS REQUIRED
FOR FIT AS LONG AS
A MINIMUM EDGE DISTANCE
OF 0.250" IS MAINTAINED
FROM THE EDGE OF ALL
HOLES AND SLOTS.
TOUCH UP WITH PRIMER &
PAINT IN ACCORDANCE WITH
AIRCRAFT MAINTENANCE
MANUAL PRIOR TO FINAL
INSTALL.

INBOARD

FORWARD

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DAO # 01-O-01

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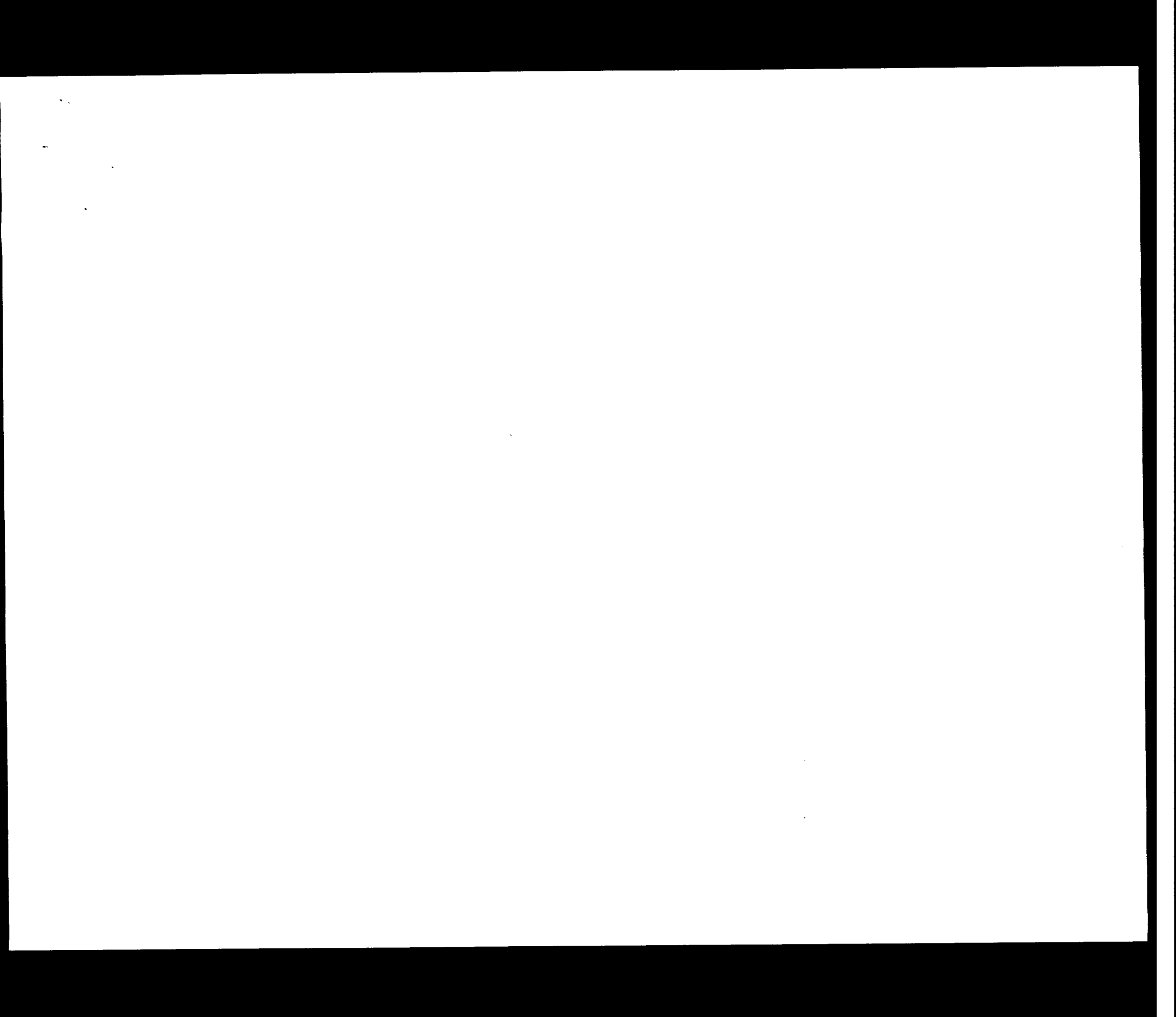
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DATE: 08.11.07

CERT. NO.: SH96-10

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DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D350-616	SHEET 6 OF 12
APPROVED	DS	TITLE	SCALE
DE APPR.		AS350/355 LITTER KIT INSTALLATION	NTS
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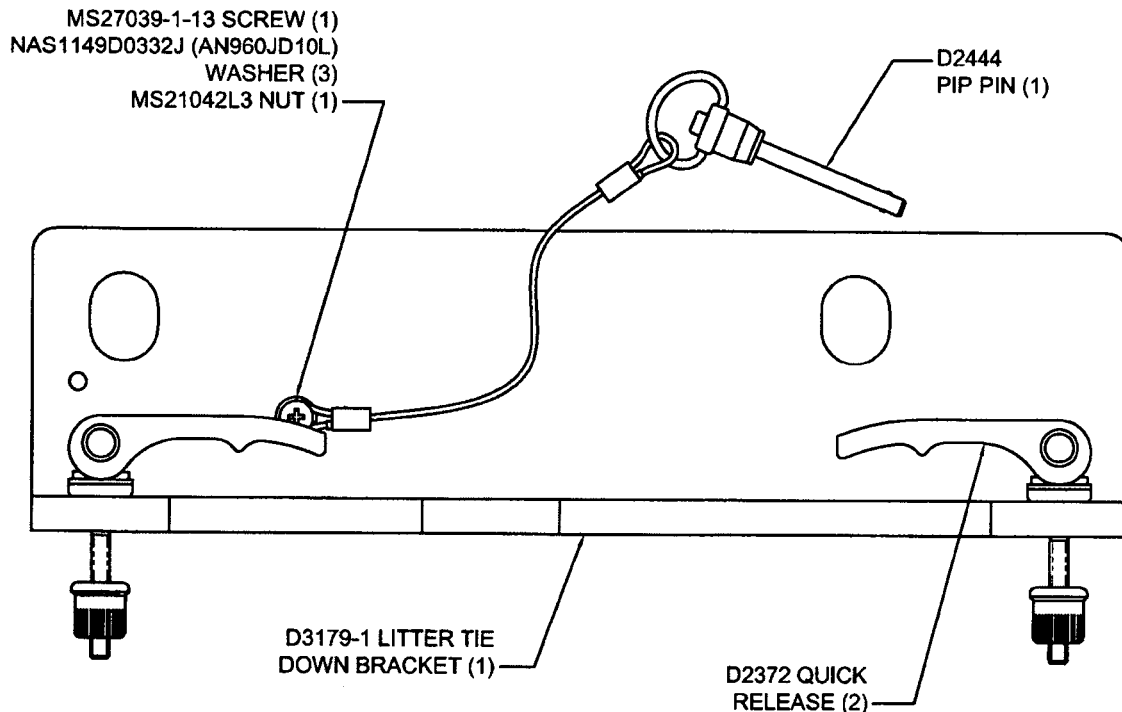


FIGURE 5: D3179-041 FWD LITTER TIE DOWN BRACKET
(PART REFERENCE)

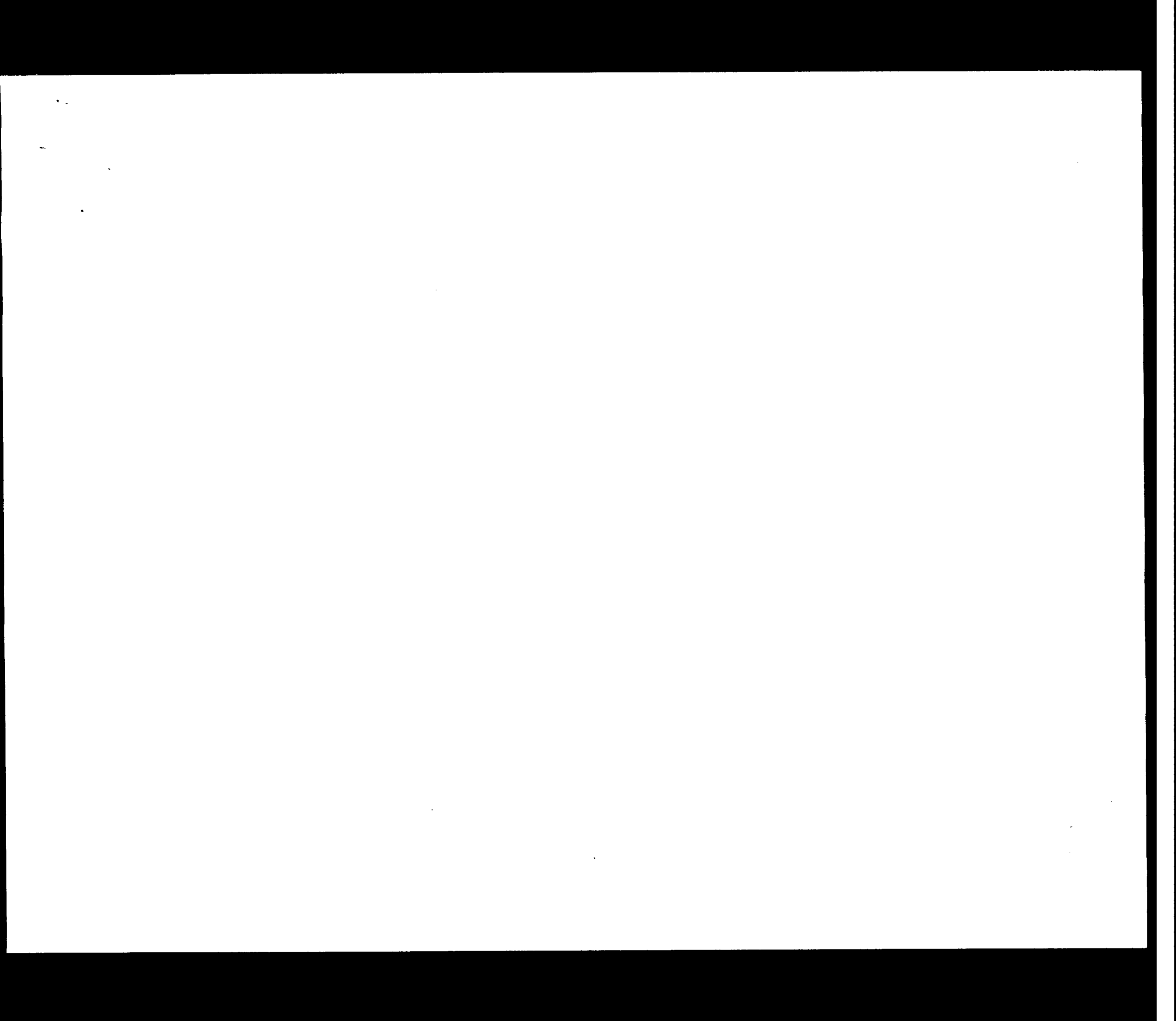
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WITHOUT NOTICE
WORK ORDER
NO. 244040

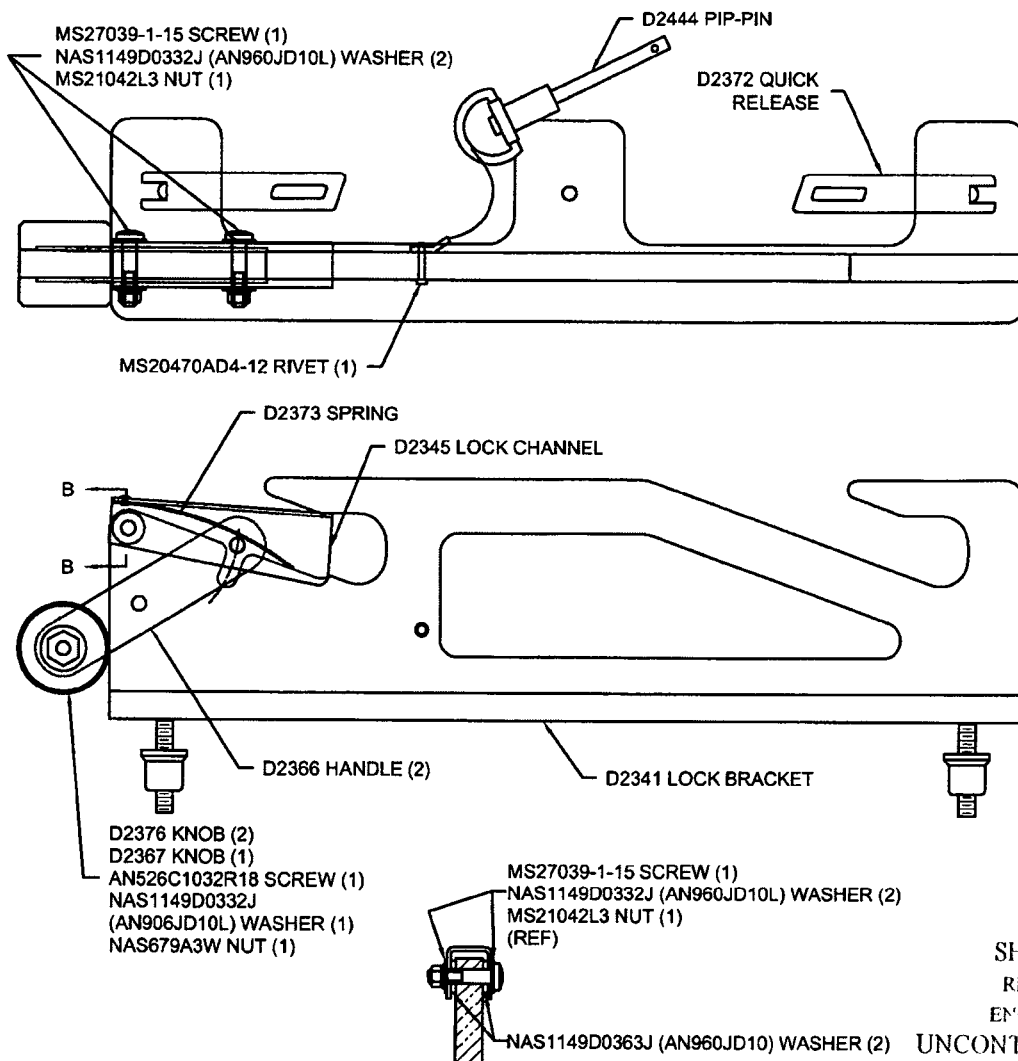
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DESIGN	BW	DART AEROSPACE LTD	
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CHECKED	DS	DRAWING NO.	REV. E
MFG. APPR.	N/A	D350-616	SHEET 7 OF 12
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SECTION B-B

FIGURE 6: D2360 TIE DOWN ASSEMBLY
(PART REFERENCE)

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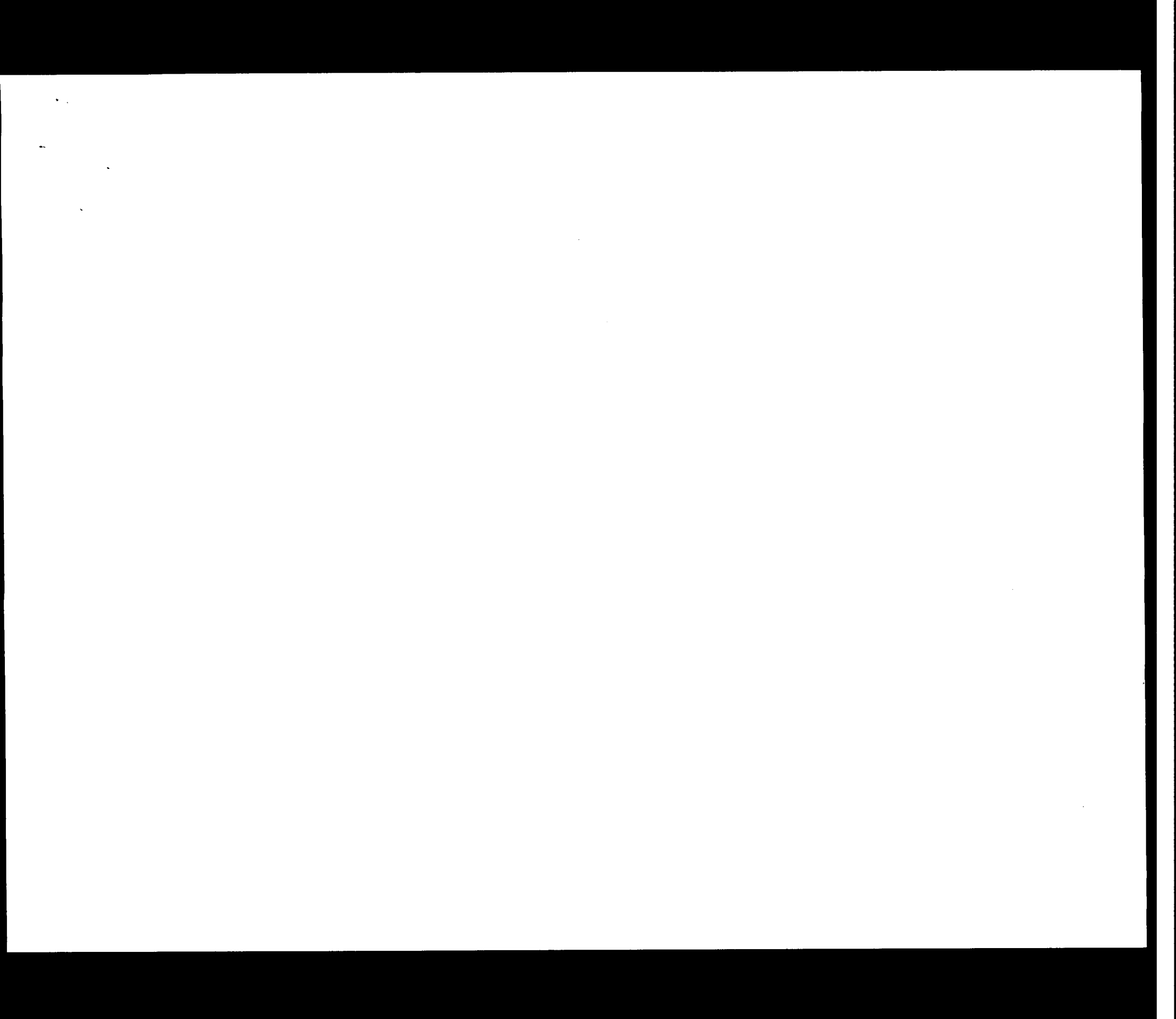
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BRANCH
DAO # 01-O-01

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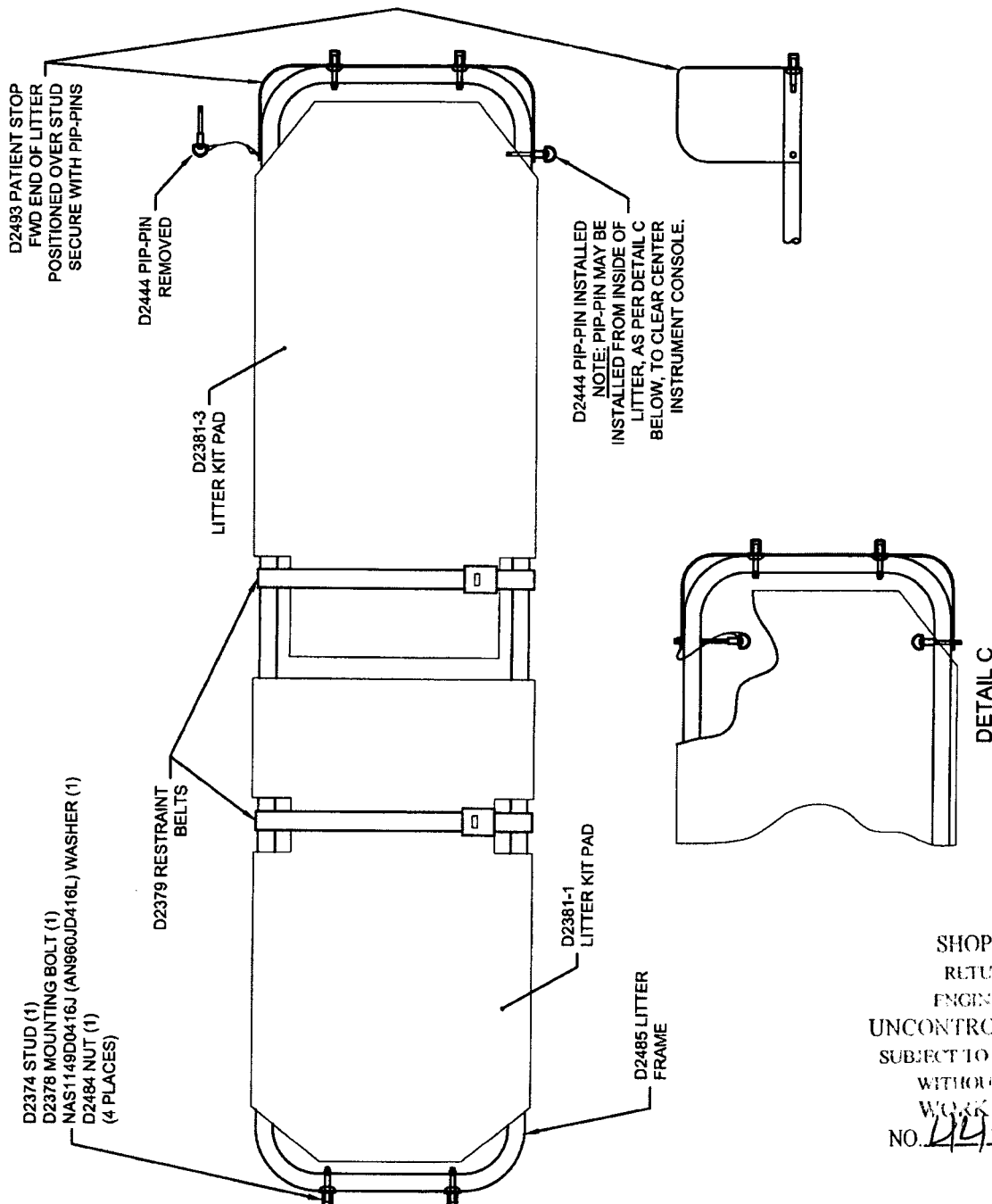


FIGURE 7: D2370 LITTER ASSEMBLY
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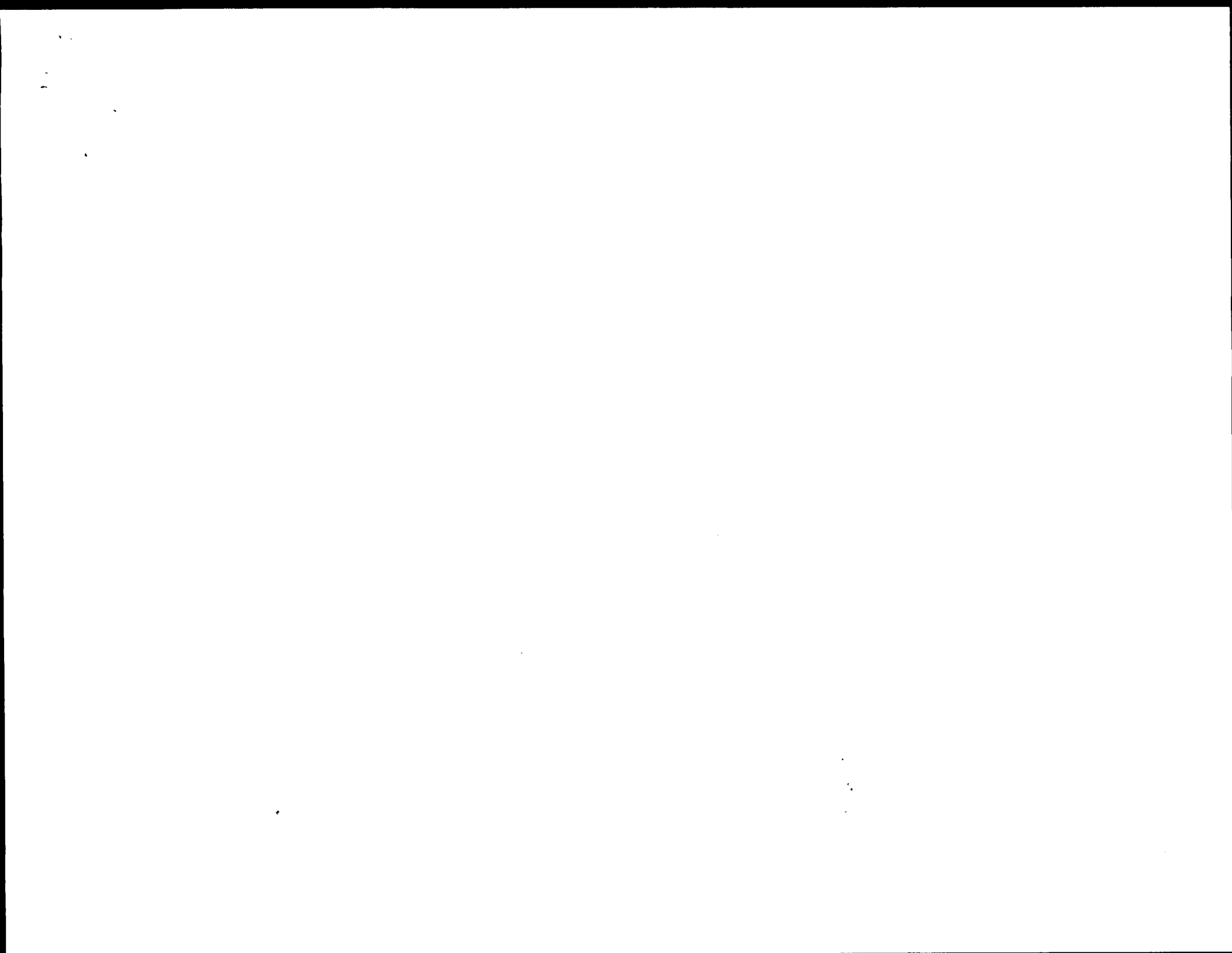
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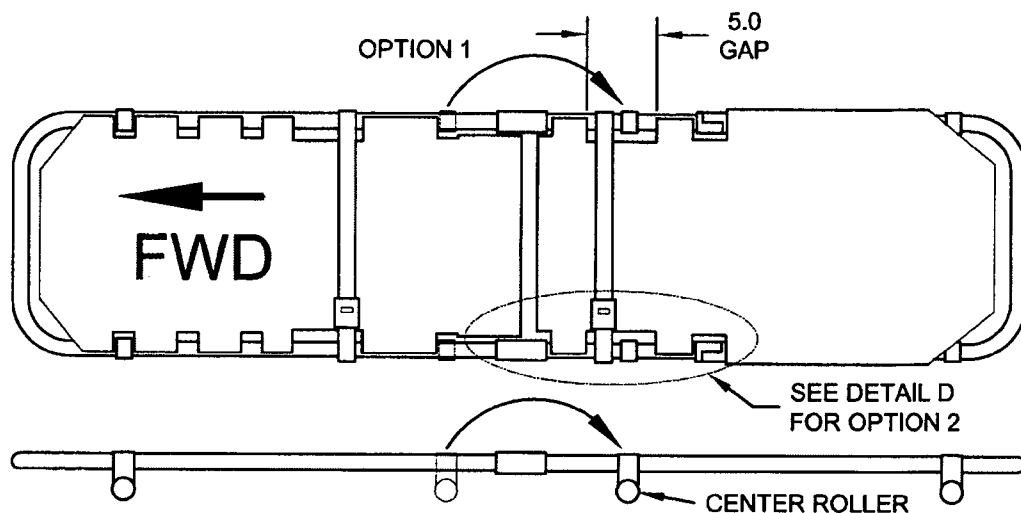
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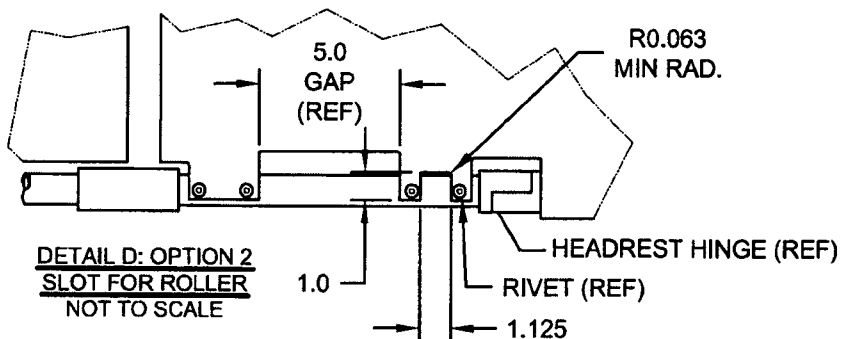
COMPATIBILITY WITH ENERGY ATTENUATING SEATS

TO FACILITATE INSTALLATION OF THE D350-616-011 LITTER KIT WITH THE SEAT RAILS OF THE ENERGY ATTENUATING SEATS, IT IS ACCEPTABLE TO MOVE THE CENTER ROLLER SUPPORT AFT AS INDICATED:

OPTION 1. MOVE THE CENTER ROLLER ANYWHERE WITHIN THE 5.0" WIDE BELT GAP SHOWN BELOW.



OPTION 2. FOR COMPATIBILITY WITH EXTENDED SEAT RAILS, IT IS ALSO ACCEPTABLE TO CUT A 1.125" WIDE x 1.00" DEEP SLOT FOR INSTALLATION OF THE CENTER ROLLER JUST BEFORE THE HEADREST HINGE AS SHOWN BELOW. ENSURE THE SLOT IS CENTERED BETWEEN THE RIVETS AND LEAVES MAX. EDGE DISTANCE POSSIBLE.



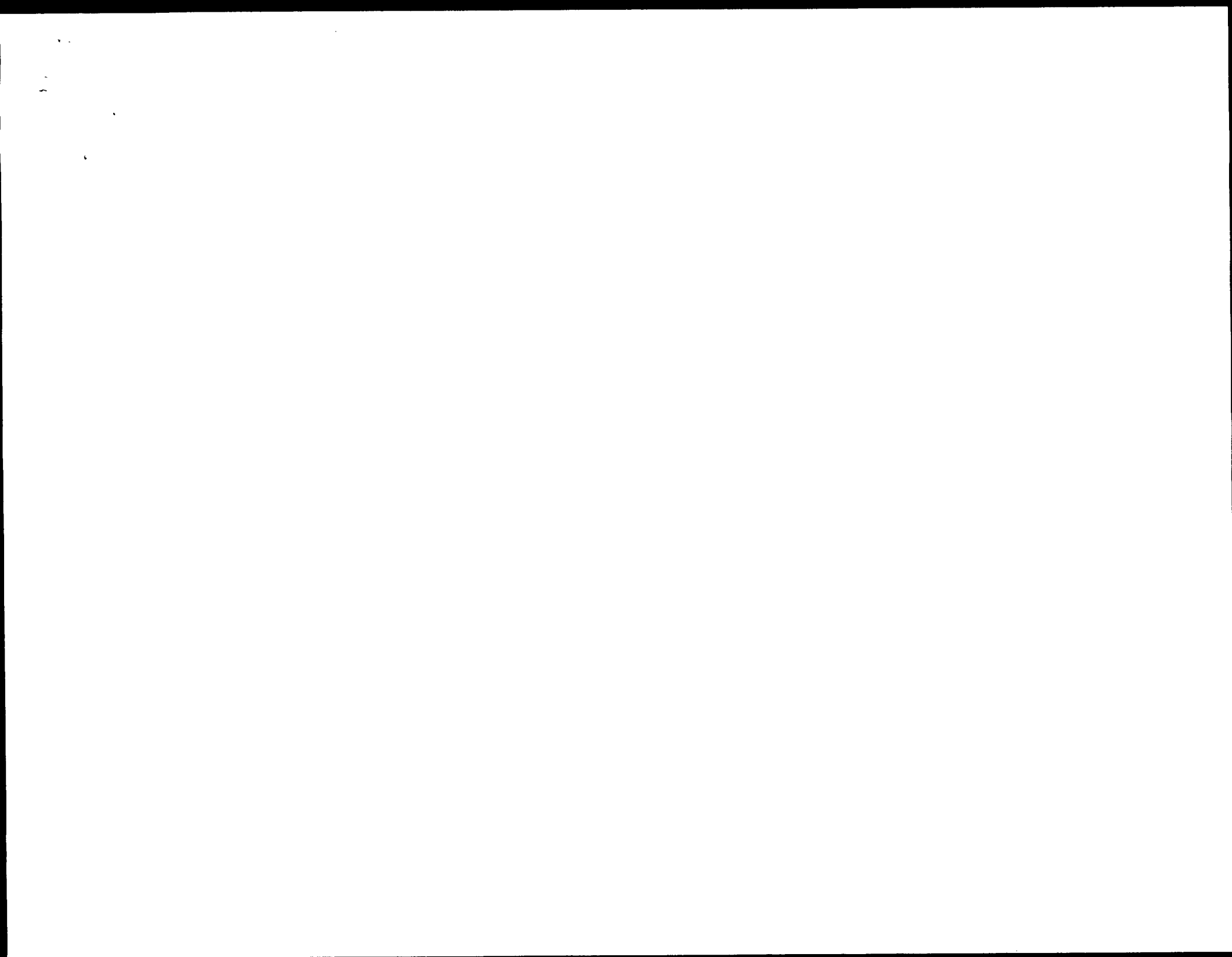
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FIGURE 8: CENTER ROLLER RE-LOCATION

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COMPATIBILITY WITH SLIDING DOORS

AIRCRAFT EQUIPPED WITH A SLIDING DOOR CAN BE MODIFIED AS FOLLOWS TO BE COMPATIBLE WITH D350-616-011 LITTER KIT.

- (1) TRIM D2344 DECK PLATE TO WITHIN 0.05" OF THE DOOR RAIL AS SHOWN IN FIGURES 9 & 10. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
- (2) DRILL FOUR 0.128" DIAMETER HOLES IN D2344 DECK PLATE AS SHOWN IN FIGURE 10. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
ATTACH D2344 DECK PLATE PER IIN-D350-616 REV. A. IN THE FOUR DRILLED HOLES, FASTEN TO AIRCRAFT FLOOR SKIN WITH AN ADDITIONAL FOUR MS20426AD4-5 BLIND RIVETS.
- (3) TRIM FAIRING AS SHOWN IN FIGURE 10.

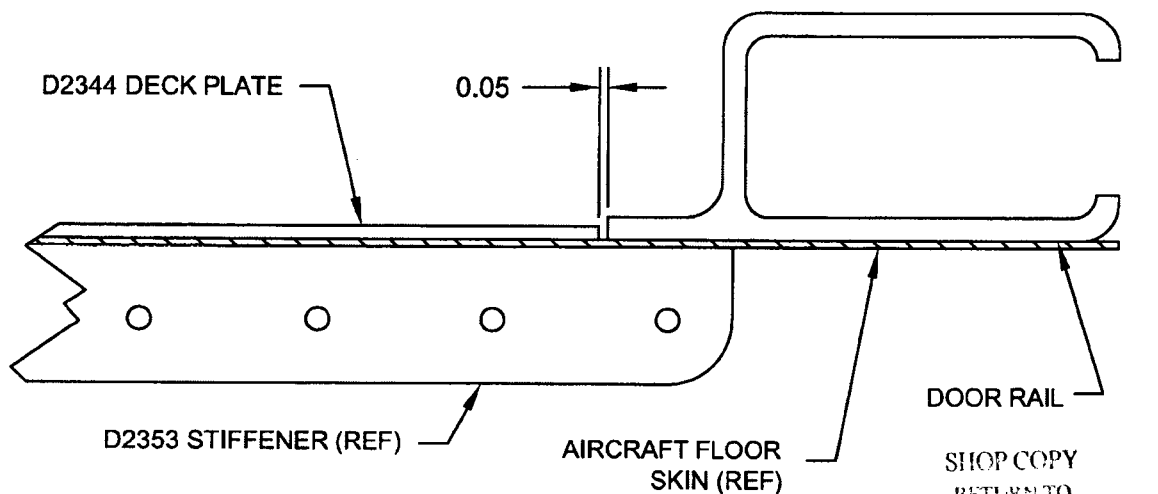


FIGURE 9
VIEW LOOKING AFT

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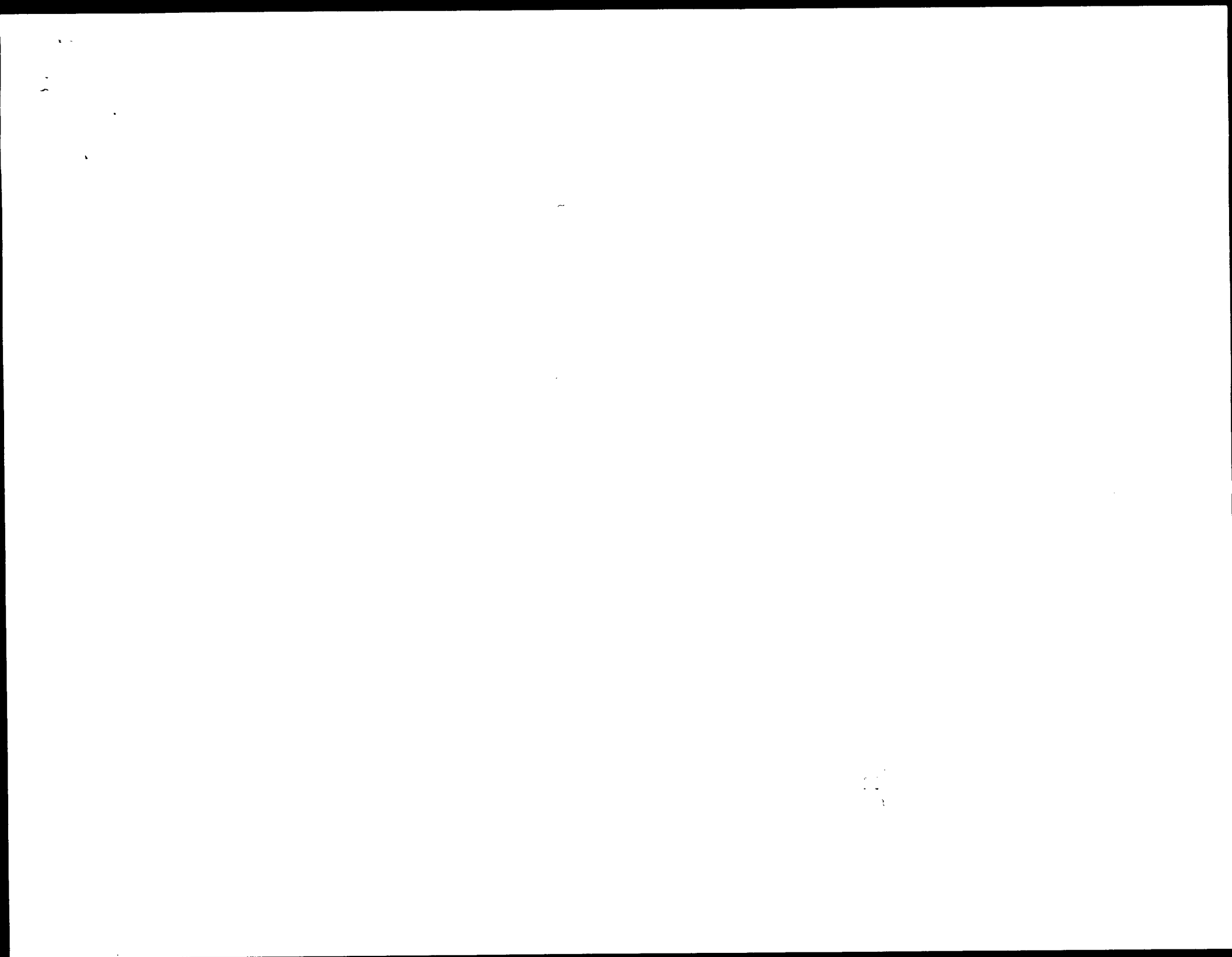
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COMPATIBILITY WITH SLIDING DOORS

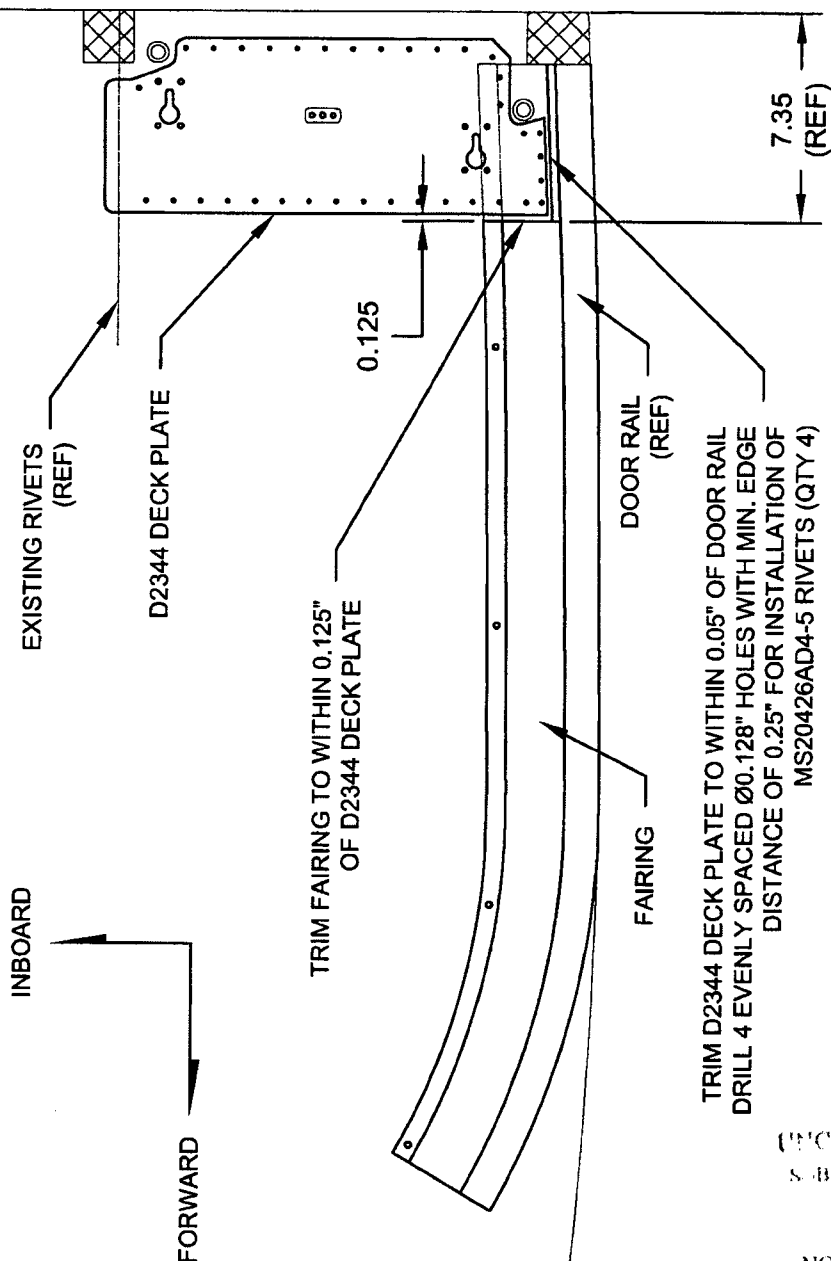


FIGURE 10

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